

637-011

Dart Aerospace Ltd.

Date: Thursday, 02/04/2009 10:35:34 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SKID TUBE ASSEMBLY
<b>Job Number</b> :	46801A		
<b>Estimate Number</b> :	10023		
<b>P.O. Number</b> :		<b>Part Number</b> :	D205634041
<b>This Issue</b> :	02/04/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2580 REV D
<b>First Issue</b> :	02/04/2009	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	46799A	<b>Drawing Revision</b> :	F
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	JUD 09.04.01	<b>Due Date</b> :	17/04/2009
<b>Comment</b> :	Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ Est Rev. O 06.02.28 Added paperwork EC Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM Est Rev:Q 09-03-19 rev.f as per IIN DD verified by:EC		

Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG002

2.0	D25001190	Ext'n -1" Beam Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	40150

D 49-4-2

3.0	D2596	Web, 205 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	B416904

m' 09-04-02 (P)

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburrr ends

3-Acid etch and Alodine tube per QSI 005 4.1

m' 09-04-02 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 46801A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

① M 9-4-2

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)
- 2-Open holes to 0.500" as per Dwg D2580without cutting fluid
- 3-Countersink holes as per Dwg D2580without cutting fluid
- 4-Deburr and blow out all chips from inside of tube
- 5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	MB 111081	
Sikaflex expire date: 10-01-01			
Start Time: 4:15		Date: 09-04-02	
Fin Time: 7:45 AM		Date: 9-4-02	

M 9-4-2

MB 09-04-02

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

9-4-6

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

9-4-7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 46801A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 09/04/08

10.0

D25763

Step (maching detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	BE 43504

BE 09/04/08

11.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	BE 43988

BE 09/04/08

12.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R Aluminum Rod

BE 09/04/08

3-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R Aluminum Rod

BE 09/04/08

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

AWM 9-4-13

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Job Number: 46801A

Part Number: D205634041

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/04/13 (X)

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/13 (X)

15.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Pressure wash as per QSI 005

HL 09-01-15 (20)

16.0 POWDER COATING POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3.5.1

START TIME: 2:30  
OVEN TEMPERATURE: 320°  
FINISH TIME: 5:00

BR 09-04-15

Φ -

17.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/16 (1)

18.0 D2855 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap  
Batch: B42343 UMD1 BR

09/04/16

19.0 AN35A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt  
Batch: M100188 UMD1 BR

09/04/16

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Job Number: 46801A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: m109632

UMD/ BR

09/04/16

21.0

ALS71032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch: m1086006

UMD/ BR

09/04/16

22.0

AN3C4A

BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch: m111193

UMD/ BR

09/04/16

23.0

AN960C10L

washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

Batch: m111127

UMD/ BR

09/04/16

24.0

D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: ~~B448889~~ B45827

UMD/ BR

09/04/16

25.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B46186

UMD/ BR

09/04/16

26.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B46446

UMD/ BR

09/04/16

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 46801A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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27.0	D356413	Wearshoe
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B45409

UMD/ BL

09/04/16

28.0	D356411	Wearshoe
------	---------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B45823

UMD/ BL

09/04/16

29.0	D35649	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B45825

UMD/ BL

09/04/16

30.0	D35645	Wearshoe
------	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B46444

UMD/ BL

09/04/16

31.0	D25943	O-Ring, 205 Skidtube
------	--------	----------------------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch: B29908

UMD/ BL

09/04/16

32.0	D25941	Plug, 205 Skidtube
------	--------	--------------------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch: B46435

UMD/ BL

09/04/16

33.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

(X1)

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

M 111087

UMD/ BL

09/04/16



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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 46801A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

Sikaflex expire date: 10/20

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: 10/20

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M11013

UMD/ FX

09/04/17

MD/BL  
09/04/16

34.0

QC5

INSPECT WORK TO CURRENT STEP



8090417



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

PP 46801

9/4/20

12

SP

36.0

QC21

FINAL INSPECTION/W/O RELEASE



1

Comment: FINAL INSPECTION/W/O RELEASE

09/04/21

Job Completion



h 09.04.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector





Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

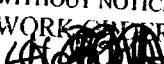
**DART****RELEASED**  
07.06.28 #

DESIGN 	DRAWN BY 	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL  $\varnothing 0.297$  HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241.  
291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK CENTER  
NO. 

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

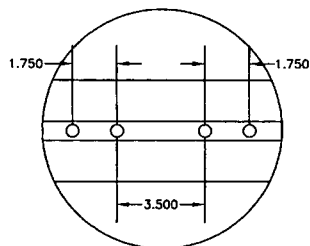
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

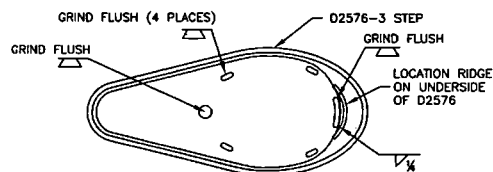
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

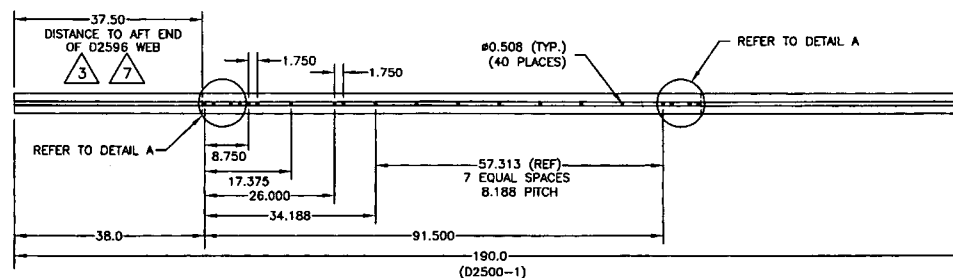
**DETAIL A**  
SCALE 5:24



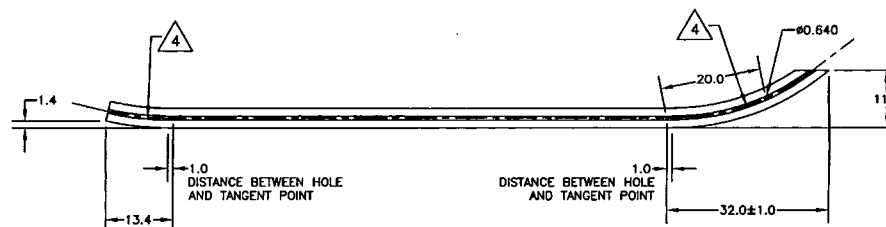
**DETAIL B**  
SCALE 5:24



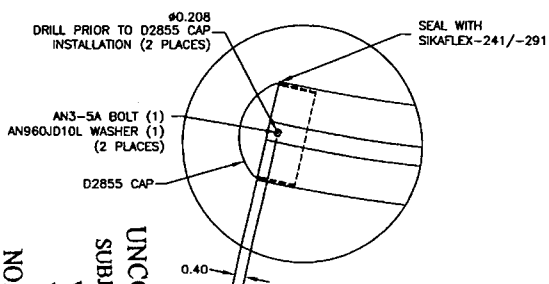
**D2580-1 DRILLING DETAIL**



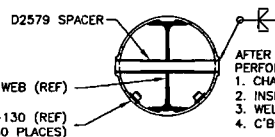
**D2580-1 BENDING AND CUTTING DETAIL**



**DETAIL C**  
SCALE 5:24

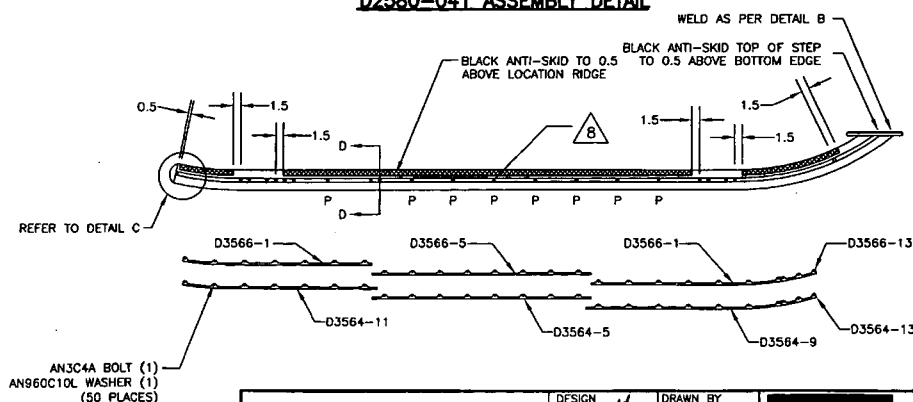


**SECTION D-D**  
SCALE 5:24



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:  
1. CHAMFER HOLE 0.050 X 45°  
2. INSERT D2579 SPACER (20 PLACES)  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

**D2580-041 ASSEMBLY DETAIL**



**D2580-041 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	DRAWN BY	<b>DART</b>	DART AEROSPACE LTD.
CHECKED	APPROVED	DRAWING NO.	REV. D
DATE		D2580	SHEET 2 OF 3
07.02.27		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

NO. 468017  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
RETURN TO  
ENGINEERING  
SHOP COPY

RELEASED  
07-06-28-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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RELEASED  
07-06-28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576

DRILL PRIOR TO D2855 CAP  
INSTALLATION (2 PLACES)

SEAL WITH  
SIKAFLEX-241/-291

AN3-5A BOLT (1)  
AN960JD10L WASHER (1)  
(2 PLACES)

D2855 CAP

SEE NOTE ii)

0.40

N  
S

D2579 SPACER

D2586 WEB (REF)

7-1032-130 (REF)  
(TYP 50 PLACES)

AFTER PERFO

1. CHA
2. INS
3. WE
4. C'B

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

37.50  
DISTANCE TO AFT END  
OF D2500 WEB

3  
7

1.750 1.750

0.508 (TYP.)  
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750  
17.375  
26.000  
34.188

57.313 (REF)  
7 EQUAL SPACES  
8.188 PITCH

38.0 91.500 190.0  
(D2500-1)

(MAKE FROM D2380-1 DRILLING DETAIL)

5.985  
1.4  
5.338 (REF)  
51.340  
39.580  
5.915  
3.630 (REF)  
#0.508 (8 PLACES)  
#0.640  
20.0  
11.5  
1.0  
32.0 ± 1.0  
1.0  
13.4  
4  
4

DISTANCE BETWEEN HOLE AND TANGENT POINT

DISTANCE BETWEEN HOLE AND TANGENT POINT

[illegible]

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	DRAWN BY <i>RH</i>
	APPROVED <i>JK</i>

DRAWING NO.	REV. D
D2580	SHEET 3 OF 3
TITLE	SCALE
205 SKIDTUBE ASSEMBLY	1:24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



NO. 195

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 46799A  
Part number: D205 634 041  
Description: 205 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:  pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier P. Elliott Date of Test Coupon 09-04-08

Welder Barclay Elliott Date of Test Coupon 09/04/08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld